PROJECT TITLE : SPECIFICATIONS AND PROCESS ASSURANCE

Period Covered : 18.4. - 22.5.1980
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0. Specifications - General

- Updated specification guidelines for manufacturing specs and material specs have been sent to the QC managers for final check before distribution.

- A European product modification request has been issued regarding the standardization of the moisture of packed cigarettes.

1. Specifications Fabriques de Tabac Réunies SA

- New specs for processing (BM 002), cigarette making (BEP 01), and packing (BEP 001) have been established for project VOITTO, cigarette Belmont Nr 1, for sale in Finland. The specs have limitted validity, for the production of this brand by the licensee ATO Finland is planned later on.

- Specs for cigarette making (MLB 01) and packing (MLB 036 and MLB 037) have been distributed for the production of Marlboro King Size in 20s hinge lid pack, for sale in Norway and Sweden.
The replacement of the 80 mm 10s packs (MLF 036 and MLF 037) by 85 mm hinge lid 10s packs (MLA 036 and MLA 037) is planned for September, 1980.

- Completely reviewed specs have been established for project Everest II, i.e. the re-engineered cigarettes FLI Flint and FLK Flint Box King Size.

- The after-cutting solution has been cancelled on blend NPF North Pole. The filter length has been increased from 18 to 20 mm.

2. Specifications Intertaba S.p.A. Zola Predosa

- The RTD of the filter MAE-120 34.7305 has been brought to the standard value of 480 mm WG (previously 450).

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3. Specifications PM Holland

- Complete manufacturing specs have been issued for the production of the UK Marlboro MLB 154.

- In addition to Eindhoven, the Bergen oZ plant will also produce Marlboro King Size MLK for sale in Italy and France.

4. Specifications PM Germany

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5. Specifications Weltab SA Bruxelles

- Cigarette making and packing specs have been issued for the production of MER Merit Filter cigarettes, for sale in Italy.

6. Specifications PM London

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7. Specifications Licensees

- Bulgaria:
  Provisional processing specs have been established for the Marlboro blend, planned to be processed in Stara Zagora. The cigarettes are produced at 60 km distance, in Plovdiv.

- Italy:
  Filters with a diameter of 7,88 instead of 7,90 mm are now supplied to MONITAL.

- Finland:
  After the first production, the cigarette making specs for Belmont Extra Mild BEO 01 have been adapted.

- DDR:
  The Nordhausen spec file, for the production of MLG Marlboro 100s Red have been completely reviewed.

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11.4 RTDs and Dilution

An inventory of the results of the diluted and semi-diluted MLF Marlboros during the last 15 months is being set up, on PME level.

11.5 Foil Mentholating

Two PME methods "Process Assurance" will be distributed during the week of May 26th, 1980:

- Mentholating of inner aluminium foil No 715
- Storage and use of mentholated alu foil No 716

11.6 Burley Treatment

After receipt of the information outstanding from PMH Bergen op Zoom, and following the visit to PMG Berlin (1.-4.6.1980),, the final report on this subject will be written and distributed.

11.7 Kitchen and Pre- and After-Cutting Solutions

The process study has been concluded for FTR, WELTAB, and PMH.

The final report will be written after the visits to PMG Berlin and PMG Munich (beginning June and beginning July, 1980).

T. Bel C. Flury

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8. Material Specifications
9. PME Standard Recipes
10. Specifications on EDP

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11. Process Assurance

11.1 AccuRay

The documents relating to the discussions of AccuRay limits and checks, during the QC PME meeting of April, will be distributed shortly. They will have provisional character. In fact, following the meeting, new proposals have been presented by the FTR production management on the one hand, and by several QC managers on the other hand. These proposals will be studied, final solutions will be found by the AccuRay specialists and new procedures issued.

11.2 Non-Tobacco Material Weights in Filter and Cigarette Making Specifications

A PME method "Process Assurance" for the determination of the glue weight on the cigarette seam has been distributed to the QC managers and the trials are presently run in the different production centres..

A preliminary test for the determination of the glue weight on the tipping paper and in the filter will be made in FTR, before the establishment of the corresponding PME Methods.

11.3 Filter and Cigarette Diameter

A PME product modification approval from Product Coordination and from the head of PME QA & Development is available for the standardisation of the cigarette diameter to 7,95 instead of 7,975 mm. The filter diameter is planned to be reduced to 7,86 mm for white and combined filters and to 7,80 mm for semi-manufactured filters.

This modification will now have to be handled on European level. The office Specs/Process Assurance will contact PME Product Coordination to set up a programme.

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